

**TECHNICAL DATA SHEET****PRODUCT DESCRIPTION**

Each kit contains the following selected mix of materials for small repairs around the boat, in the workshop, or at home.

Epoxy Resin 50ml, Epoxy Hardener 25ml, 440g Double-bias Glass Cloth 10cm x 50cm, Microfibre 150ml, Brush for resin application, Mixing Sticks, Latex Gloves.

**DIRECTIONS FOR USE****Usage**

Fibreglass repair, hardware installation, composite lamination and wood repair.

**Surface Preparation :**

The surface to be repaired has to be dry and clean. If surface is non-porous, sand with 80-120 grade paper.

**Directions :**

Mix OceanMaster epoxy resin base with its hardener in the ratio of 2:1 by volume or weight. Stir until the mixture is blended into a uniform consistency and colour. You will have 10 – 15 minutes working time from this point.

**General Bonding & Filling :**

Apply the mixture directly with brush. This will act as a waterproof coating. On porous surfaces, this first coat serves to pre-wet the surface. Thicken the mixture by adding and stirring in a small amount of Microfibre until it reaches the desired consistency.

Using the mixing stick, apply the thickened mixture to the mating surface and temporarily clamp the components in position. Use enough pressure to ensure good contact and to restrict movement. For filling gaps, thicken to a stiff consistency. This will allow gaps to be filled without sagging.

**Lamination :**

Lay the glass cloth onto the surface that is to be laminated. Hold it in place with masking tape or staples.

Apply the mixture directly onto the mat using the brush provided. Ensure even coverage. Start from mid-body. Proceed in a fore and aft direction.

Avoid air traps by saturating the glass cloth with the mixture.

**Curing :**

The epoxy resin should reach a firm cure in 2 – 3 hrs and a hard cure in 12 hrs at 30°C. When it is hard cured, the epoxy would have reached about 90% of its ultimate strength. Clamps holding the substrates in position can be removed at this point. The mixture will continue to cure over the next few days at room temperature. This curing period can be substantially accelerated by applying moderate heat.

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